

Work Order ID 71056

Tuesday, June 21, 2011 1:31:27 PM

Page 1

Item ID: D2939-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle LH In, 206

Start Date: 6/21/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SL 11-07-19

④

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11-07-19

1

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

SL 11-07-19

4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

R 11-7-19



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

4- 6 BK 11-7-19

Hand Finishing

155

0.00



SprayPaint

Memo

0.00

RT 11-07-26 (24)

Spray Painting

PRIME B 117319
DELFLEET BLUE B 118395
DELFLEET CLEAR B 118057

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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

11/6/27 07 27 (4)

170

Identify as per dwg & Stock Location: Y27

0.00



Packaging

Memo

0.00

Packaging

11/6/27 S/P (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/27 (4)

11-07-27 (4)

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Picklist Print

Tuesday, June 21, 2011 1:31:32 PM

Page 1

Work Order ID: 71056

Parent Item: D2939-1

Parent Item Name: Saddle LH In, 206



Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001

Manufactured

No

100

Each

49.0000

1

4



Saddle Billet



11-07-18

Location

Loc Qty

Loc Code

MAT040

44

64777

20

66965

4

69677

20

MAT40

5

69700

5

70976

4

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 71654
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.120	.120	.119		
B	0.100	0.140		.120	.121	.120	.119		
C	0.100	0.140		.115	.114	.114	.114		
D	0.210	0.230		.221	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.121	.120	.121		
O	0.540	0.560		.549	.549	.550	.549		
P	0.490	0.510		.499	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.250	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.261	1.261	1.260	1.259		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.575	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JL
Date: 11-07-18

Audited by: RZ
Date: 11-7-19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

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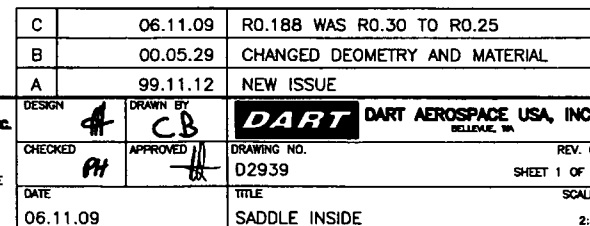
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SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71034



1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3



3) BREAK ALL SHARP EDGES 0.010 TO 0.020

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE INCHES

6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
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DART AEROSPACE USA, INC.

DESIGN	A	DRAWN BY	CB	 DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	APPROVED		
DATE		DRAWING NO.		REV. C
06.11.09		D2939		SHEET 1 OF 1
		TITLE		SCALE
		SADDLE INSIDE		2:3

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